

Work Order ID 60854

Monday, July 26, 2010 10:43:25 AM



Page 1

Item ID: D2877

Accept

Revision ID:

Item Name: Saddle Spacer

Start Date: 7/26/2010 Start Qty: 20.00

Required Date: 8/3/2010 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2877

Rev B

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2877 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-deburr

60854 - 125

B10-7-08

(24)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B10-7-08

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

510108103

counted
x24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60854

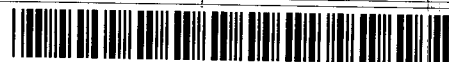
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Page 2

Item ID: D2877

Accept



Revision ID:

Item Name: Saddle Spacer

Setup Start



Stop



Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
	Small Fab								
Small Fab	Memo	0.00							
	Deburr if necessary								
	<i>u/s</i>								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							
150	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00							

*2) ul 10/08/04**24**8**24 BR 10-8-4.*

W/O:		WORK ORDER CHANGES					
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Work Order ID 60854

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Item ID: D2877

Accept



Setup Start



Revision ID:

Item Name: Saddle Spacer

Stop



Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location 26

0.00



Packaging

Memo

0.00

Packaging

10/08/04
MF
242

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/04
MF
10-8-04

W/O:		WORK ORDER CHANGES						
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Picklist Print

Monday, July 26, 2010 10:43:30 AM

Page 1

Work Order ID: 60854

Parent Item: D2877

Parent Item Name: Saddle Spacer

Start Date: 7/26/2010


Required Date: 8/3/2010

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B ☐ 00.05.19 ☐ Added inspect level 8 ☐ EC
 IPP C ☐ 06.04.26 Water jet ☐ EC
 IPP Rev:D Now M6061-T6 06-06-23 JLM
 IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			110	sf	148.8600	0.0607	1.277895	1.5		
6061-T6 .125 Sheet											1810-7-28		

Location

Loc Qty

Loc Code

MAT21 148.86
 112476 4.04
 113424 0.16
 113608 96
 114352 48.66

114352

24

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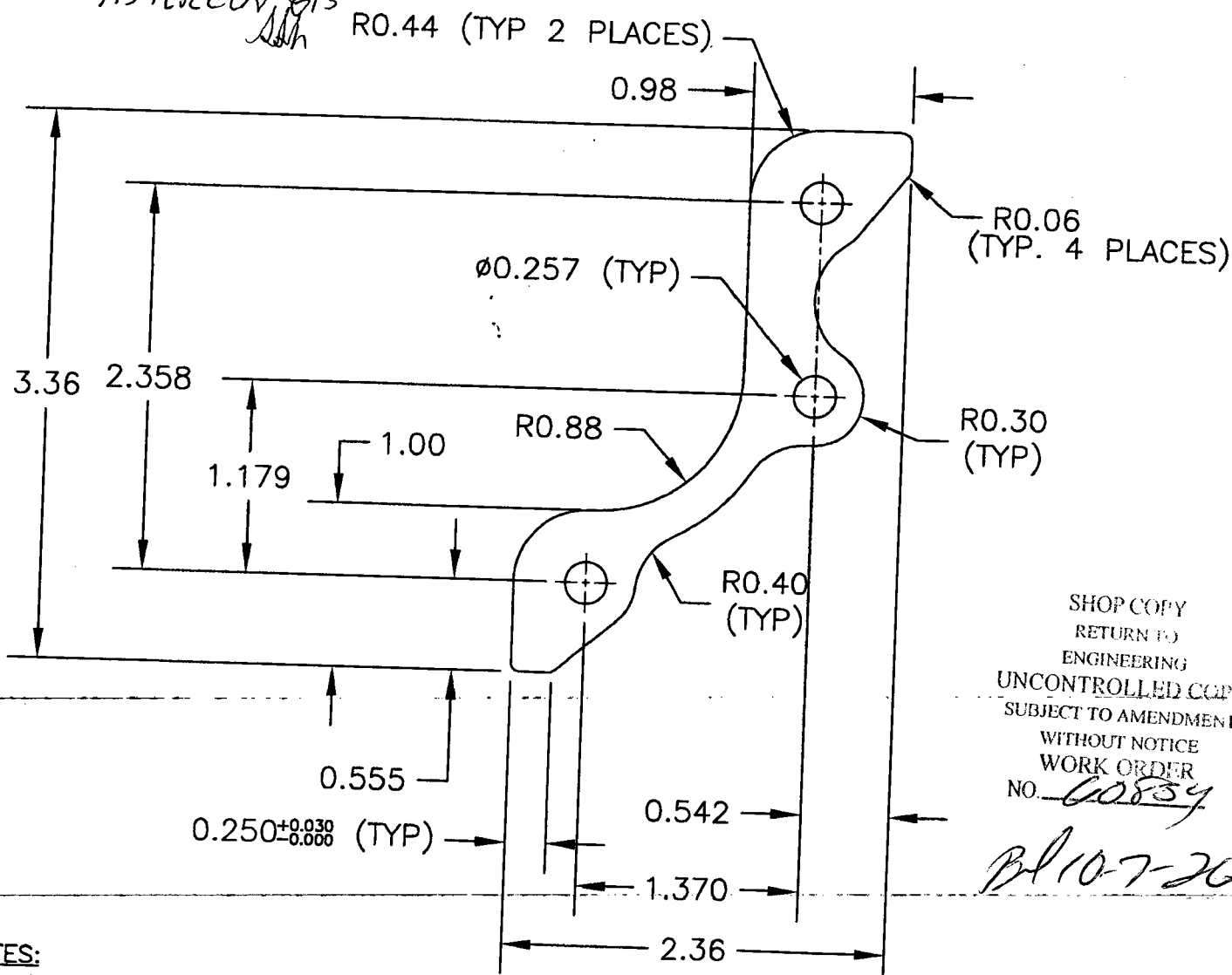
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17	TITLE SADDLE SPACER SCALE 1:1		
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED
06.06.21

AS PER ECN 813
[Signature]



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *60854*

BL10-7-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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